

TH35I Low Chromium Carbide

DESCRIPTION

TH35I is a cored wire specifically designed for arc spray systems. It produces a hard, well bonded coating that is abrasive and corrosion resistant. TH35I can be easily machined with carbide tools, yielding a smooth, low coefficient of friction surface finish, suitable for a number of applications.

TYPICAL DEPOSIT CHARACTERISTICS:

- Bond Strength 5000 psi
- Typical Hardness HRC 39-42
- Deposit Rate 18-65 lbs. per hr.
- Deposit Efficiency 60-70%
- Wire Coverage 4 sq. ft. per lbs. @ 8-10 mils thick
- Surface Finish Textured

SURFACE PREPARATION:

Surface should be clean, white metal, with no oxides (rust), dirt, grease, or oil on the surface to be coated. NOTE: It is best not to handle surfaces after cleaning. Recommended method of preparation is, to grit blast with 24 mesh aluminum oxide, rough grind, or rough machine in a lathe. *Thermion recommends a 3.5 mil minimum anchor tooth profile.

Applications:

- Boiler Tubes
- Reclamation of Dimension
- Fan Blades
- Paper Rolls
- Food Processing

NOMINAL CHEMICAL COMPOSITION (wt. %):

Cr	Ni	C	Mn	Si	Mo	Fe
26.0	3.0	1.7	1.6	1.6	0.8	Bal

RECOMMENDED SPRAY PARAMETERS:

Diameter	Air Pressure	Voltage	Amperage	Standoff
1/16" (1.6mm)	80-100 psi	28-32	100-300	4-7" (10-17cm)

Parameters are typical and may vary depending on equipment used.

STANDARD SIZES & PACKAGING:

Diameter	Packaging
1/16" (1.6mm)	25#